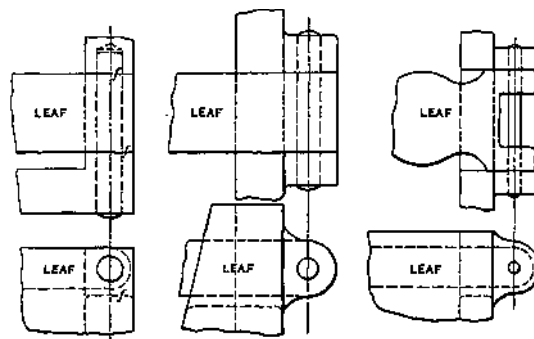


## CLAMPING DEVICES

The size of these thumb-screws is made according to the strain on the leaf and the size and design of the jig. No standard dimensions could be given for this kind of screw.

The hinged bolt or latch bolt, shown in Fig. 31, is also commonly used. Here *A* represents an eye-bolt, which is connected with the jig body by the pin *B*. The leaf or movable part *C* of the jig is provided with a slot in the end for the eye-bolt, this slot being a trifle wider than the diameter of the bolt. The threaded end of the eye-bolt is provided with a standard hexagon nut, a knurled-head nut or a wing-nut, according to how firmly it is necessary that the nut be tightened.

When the leaf is to be disengaged, the nut is loosened up



**Fig. 32. Detail Designs of Hinged Leaves**

enough to clear the point at the end of the leaf, and the bolt is swung out around the pin *J*?, which is driven directly into lugs projecting out from the jig wall, a slot being provided between the two lugs, as shown, so that the eye-bolt can swing out with perfect freedom. At the opposite end, the leaves or loose parts of the jig swing around a pin the same as in Fig. 29, the detailed construction of this end being, most commonly, one of the three types shown in Fig. 32. It must be understood that to provide jigs with leaves of this character involves a great deal of work and expense, and they are used almost exclusively when one or more guide bushings can be held in the leaf.

Quite often drill jigs have a bushing plate in the form of a leaf which swings on a hinge out of the way so that the piece